

# Work Order ID 48675

July 2, 2009 3:05:21 PM



Page 1

Item ID: D3789-5

Accept



Setup Start



Revision ID: A

Stop



Item Name: Clamp

Start Date: 07/02/2009 Start Qty: 15.00



Cust Item ID:

Required Date: 07/15/2009 Req'd Qty: 15.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3789

Rev A

100

0.00



PURCHASING

Purchasing

Memo

0.00

mp 07/07/14

15

0

Purchasing

Send Blanks To: Metec/Mast Precision

Machining IP/O: Machine D3789-5 as per Dwg D3789

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

120

0.00



QC6- Inspect dimensions to drawing

QC-2

Memo

0.00

mp 07/07/14

15

0

Quality Control

QCB.

Second check.

mp 07/07/14

15

0

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QC:

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Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

09-07-14 (10)  
Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

\*\*\*\*\*Mask bearing bore prior to powder coat\*\*\*\*\*  
TIME: 2:30pm OVEN TEMPERATURE:  
3:00pm FINISH TIME: 320°F

START

1112148 09-07-14 (XLS)

# Work Order ID 48675

July 2, 2009 3:05:21 PM



Page 3

Item ID: D3789-5

Accept



Setup Start



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Stop



Item Name: Clamp

Start Date: 07/02/2009 Start Qty: 15.00



Cust Item ID:

Required Date: 07/15/2009 Req'd Qty: 15.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3-Inspect Part Finish

0.00



QC

*OK 09-07-14 (15)*  
Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

*463*

0.00



Packaging

Memo

0.00

Packaging

*9/7/14 (15X) SD*

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09/07/15 JF*  
*MF 09-07-15*

# Picklist Print

July 2, 2009 3:05:21 PM

Work Order ID: 48675

Parent Item: D3789-5RevA

Parent Item Name: Clamp


Comments:

Start Date: 07/02/2009

Required Date: 07/15/2009

Start Qty: 15.00

Required Qty: 15.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2423RevB1		Manufactured	No			100	f	767.4300	1.1053			
												
Lug Extrusion												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	767.43	
43722	219.5	43722
44529	22.39	
45800	525.54	

1.181

mmj  
07/07/15

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 48675
<b>Description:</b> <i>Clamp</i>		<b>Part Number:</b> D3789-5
<b>Inspection Dwg:</b> A	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	$\pm .03$	4.208	✓			
3.45	$\pm .03$	3.448	✓			
.75	$\pm .03$	.747	✓			
1.50	$\pm .03$	1.500	✓			
.41	$\pm .03$	.412	✓			
.40	$\pm .03$	.395	✓			
.53	$\pm .03$	.530	✓			
.38	$\pm .03$	.381	✓			
R1.470	$\pm .010$	1.469	✓			
R.002	$\pm .03$	.005	✓			
R.06	$\pm .03$	.06	✓			
R.34	$\pm .03$	.34	✓			
R.03	$\pm .03$	.03	✓			
R.38	$\pm .03$	.375	✓			
P.257	$\pm .005$	.258	✓			

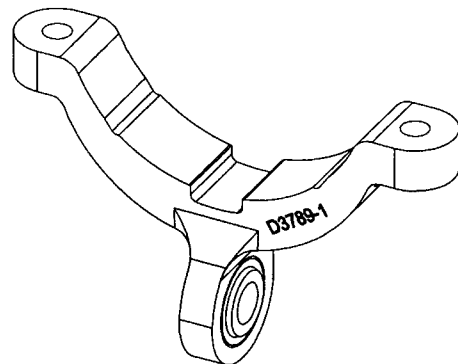
<b>Measured by:</b> <i>DP</i>	<b>Audited by:</b> <i>ml</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/07/13	<b>Date:</b> 09/07/14	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

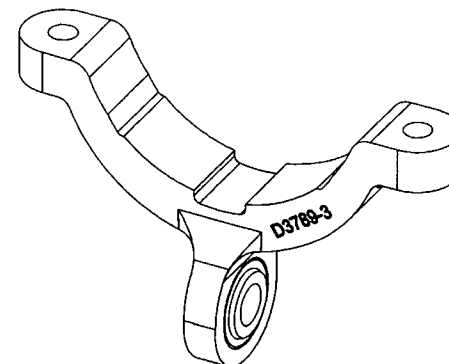
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[illegible]

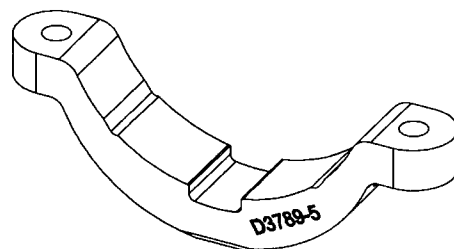
H:\FORMS\Quality Assurance\approved QA\NCRWO RevD



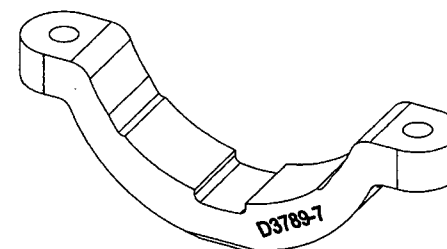
**D3789-1 CLAMP**



**D3789-3 CLAMP**



**D3789-5 CLAMP**



**D3789-7 CLAMP**

**REFERENCE ONLY**

**DEO ATTACHED**

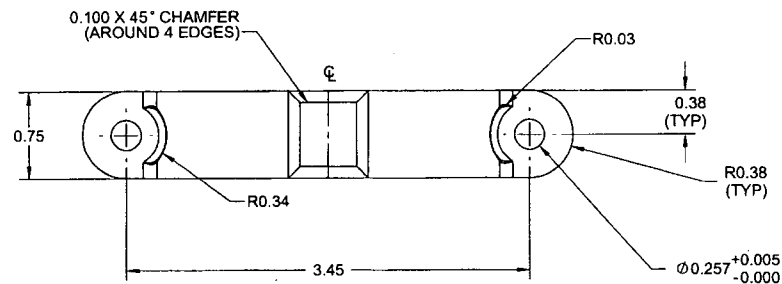
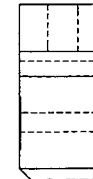
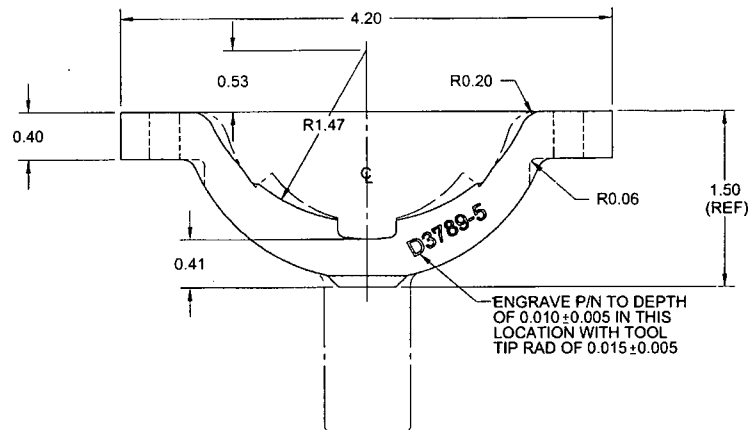
**RELEASED**  
08/12/21

**NOTES:**

- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N AS SHOWN
- 7) WEIGHT: D3789-1, 0.16 lbs  
D3789-3, 0.16 lbs  
D3789-5, 0.14 lbs  
D3789-7, 0.14 lbs
- 8) STAKE D2611 BEARING 4 PLACES EACH SIDE AFTER POWDER COAT
- 9) PART IS SYMETRICAL ABOUT  $\phi$

48675

A		NEW ISSUE		HS	08.05.21
REV.		DESCRIPTION		BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN	HS				
CHECKED		DRAWING NO.	D3789	REV. A	
MFG. APPR.		TITLE	CLAMP	SCALE	
APPROVED				NTS	
DE APPR.					
DATE	08.05.21	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			



**D3789-5 CLAMP**

**REFERENCE ONLY**

48675

**DEO ATTACHED**

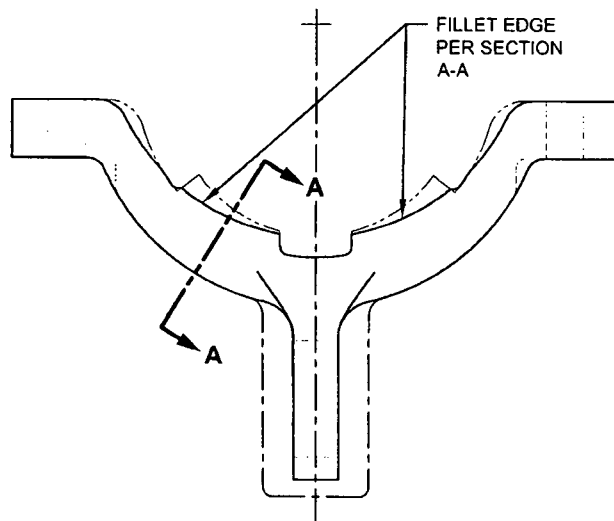
**RELEASED**  
08/12/21 MB

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO. D3789	REV. A
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
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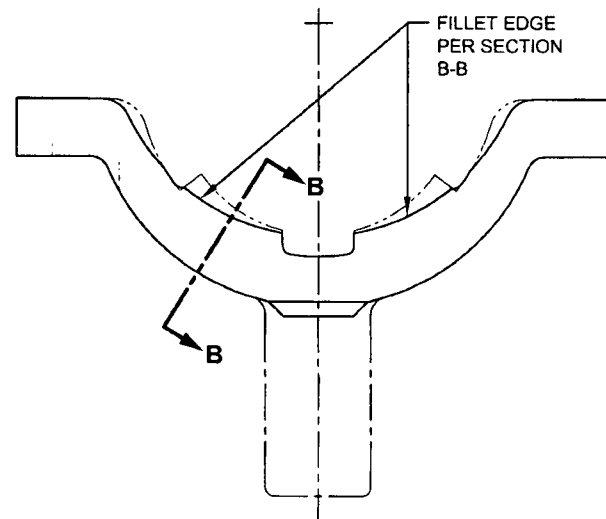
DRAWING NO. D3789	TITLE CLAMP	REV. A	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>		D.E.O. NO. D3789-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>AJS</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 09.04.20	DATE 09.04.23	DATE 09.04.23	DATE 09/04/23		DATE 09/04/23		

ADD FILLETS TO -1/-3/-5/-7 PER SECTIONS A-A AND B-B TO PREVENT CHAFING OF RUBBER CUSHIONS AS SHOWN:



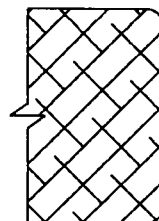
D3789-1 CLAMP

D3789-3 CLAMP



D3789-5 CLAMP

D3789-7 CLAMP



R0.06 MIN - R0.10 MAX  
2PL

SECTION A-A  
SCALE 2X

SECTION B-B  
SCALE 2X

SEE PAR 122 FOR FURTHER DETAILS

REFERENCE ONLY

RELEASED  
09/05/24

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